

cated by the arrow the work is securely clamped and, if necessary, ordinary straps may be added for holding the work.

When making tools for thin castings of odd shapes, it is often desirable to use an adjustable clamping device that can be

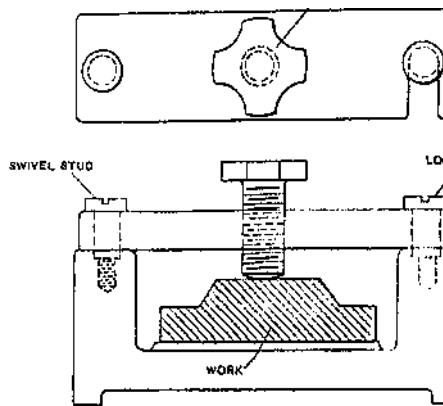


Fig. 67. Quick-acting
Clamp of Simple Design

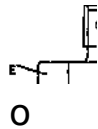
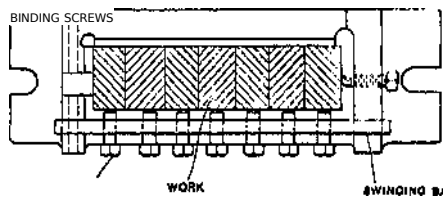


Fig. 68. Simple Form
of Gang Milling Fixture

easily moved out of the way when reloading the fixture. Such a floating clamp is shown in Fig. 70,

where the piece of work to be drilled was properly located and clamped, with the exception of one arm *f*, for which no ordinary clamp could be used. By pushing the support *A* down against the work and